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IS 1294 (1989): Household Sewing Machines - Bobbins [MED
29: Sewing Machines]



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Indian Standard

**HOUSEHOLD SEWING MACHINES —
BOBBINS — SPECIFICATION**

(Third Revision)

UDC 687'053'15

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BUREAU OF INDIAN STANDARDS
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG
NEW DELHI 110002

FOREWORD

This Indian Standard (Third Revision) was adopted by the Bureau of Indian Standards on 11 July 1989, after the draft finalized by the Sewing Machines Sectional Committee had been approved by the Light Mechanical Engineering Division Council.

This standard was first published in 1959. It was subsequently revised in 1967 and 1974. The present revision has been made up-to-date in the light of the experience gained during the last 15 years.

In preparation of this standard assistance has been derived from JIS B 9024 : 1960 'Shuttle bobbin of sewing machine for home use', issued by the Japanese Industrial Standards Committee.

Indian Standard

HOUSEHOLD SEWING MACHINES — BOBBINS — SPECIFICATION

(Third Revision)

1 SCOPE

1.1 This standard covers the requirements for bobbins for vertical oscillating shuttle type sewing machines for household purposes.

2 REFERENCES

IS No.	Title
513 : 1986	Cold rolled low carbon steel and sheets and strips (<i>third revision</i>)
1068 : 1985	Electroplated coatings of nickel plus chromium and copper plus chromium on iron and steel (<i>second revision</i>)
2500 (Part 1) : 1973	Sampling inspection tables: Part 1 Inspection by attributes

3 NOMENCLATURE

3.1 The nomenclature shall be as given in Fig. 1.

4 MATERIAL

4.1 The collar and washers shall be manufactured from cold rolled steel strip such as IS 513 : 1986.

5 DIMENSIONS

5.1 The dimensions shall be as shown in Fig. 2.

6 TOLERANCES

6.1 Tolerances on the dimensions shall be as shown in Fig. 2.

7 WORKMANSHIP AND FINISH

7.1 The washers shall be firmly riveted to the collar so that there is no relative movement under the normal working conditions. The rivetted surface on both ends shall be smooth and free from burrs.

7.2 The component shall be finished to a smooth surface all over and shall be free from burrs, sharp edges, cracks, dents or any manufacturing defects.

7.3 The bobbins shall be nickel plated to grade Fe/Ni2obCr r of IS 1068 : 1985 and the plated surfaces shall be smooth and free from plating defects.

8 SAMPLING

8.1 Unless otherwise agreed to between the supplier and the purchaser the sampling plan as given in Annex A shall be followed. For further information reference may be made to IS 2500 (Part 1) : 1973.

9 TEST

9.1 Rolling Test

When the bobbins are rolled on the smooth and flat surfaces of a glass there shall be no visible meandering or inclined movement.

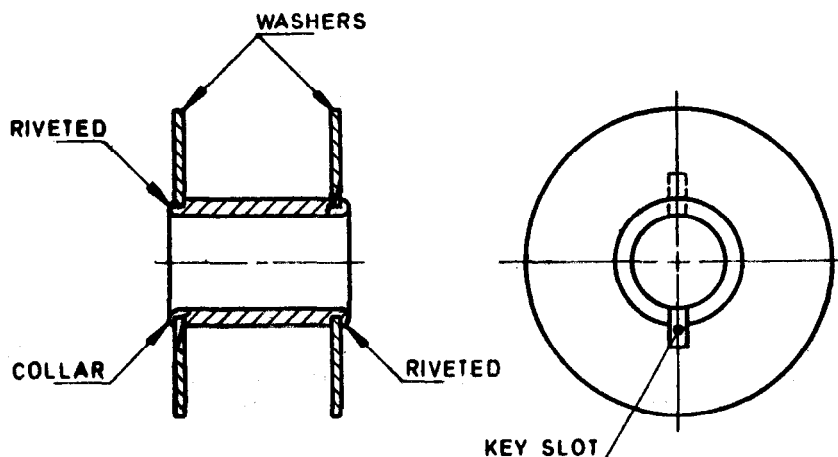
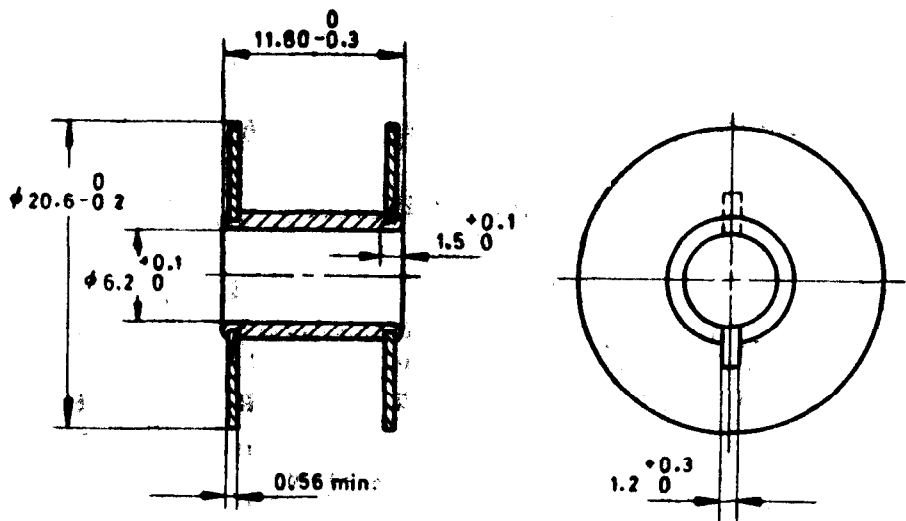


FIG. 1 NOMENCLATURE FOR BOBBINS



All dimensions in millimetres.

FIG. 2 DIMENSIONS FOR BOBBINS

9.2 When engaged with bobbin spindle of bobbin winder assembly, locking shall be good so that it shall not slip during winding.

10 MARKING

10.1 Carbons containing bobbins shall be marked with the manufacturer's name or trade-mark.

11 PACKING

11.1 Each bobbin shall be given a anti-rust coating for protection against rust. The bobbins shall then be securely packed in strong card board cartons in accordance with the best prevalent trade practice. The quantity to be packed in each carton shall be as specified by the purchaser. Each carton shall bear the manufacturer's name, trade-mark and description of contents.

ANNEX A

(Clause 8.1)

SCALE OF SAMPLING AND CRITERIA FOR CONFORMITY

A-1 SCALE OF SAMPLING

A-1.1 Lot

In any consignment, all the bobbins of the same type and manufactured from the same material under essentially similar conditions of manufacture shall be grouped together to constitute a lot.

A-1.2 For ascertaining the conformity of the lot to the requirements of the specification, tests shall be carried out for each lot separately. The number of bobbins to be selected at random for this purpose shall be in accordance with col 1 and 2 of Table 1.

A-1.3 If the bobbins are packed individually, in order to ensure the randomness of selection, random number tables shall be used. In case such tables are not available, the following procedure may be adopted:

Table 1 Scale of Sampling and Permissible Number of Defectives
(Clauses A-1.2; A-1.4 and A-2.1)

Number of Bobbins in the Lot <i>N</i>	Sample Size <i>n</i>	Permissible No. of Defectives
(1)	(2)	(3)
Up to 15	5	0
16 to 40	8	0
41 to 110	13	0
111 to 300	20	1
301 to 500	32	1
501 to 800	50	2
801 to 1 300	80	3
1 301 and above	125	5

*This ensures that lots containing only one-and-a-half percent of less defectives will be accepted most of the time.

Starting from any bobbin in the lot, count them in one order as 1, 2, 3 up to *r* and so

on, where r is the integral part of N/n (N being the lot size and n the sample size). Every r th bobbin thus counted shall be selected to constitute the sample.

A-1.4 If the bobbins are packed in different cartons, a suitable number of cartons (not less than 20 percent of the total in the lot subject to a minimum of 2), shall be chosen at random. From each of the cartons so chosen, an approximately equal number of bobbins shall be picked up from its different parts so as to obtain the required number of bobbins specified in col 2 of Table 1.

A-2 NUMBER OF TESTS AND CRITERIA FOR CONFORMITY

A-2.1 The bobbins selected according to **A-1.2** and **A-1.3** or **A-1.4** shall be examined for dimensions (*see 5*), tolerances (*see 6*), workmanship and finish (*see 7*) and rolling test (*see 9.1*). If the number of bobbins failing to meet one or more of the requirements mentioned above is less than or equal to the permissible number of defectives given in col 3 of Table 1, the lot shall be declared as conforming to the requirements of the standard.

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BUREAU OF INDIAN STANDARDS

Headquarters:

Manak Bhavan, 9 Bahadur Shah Zafar Marg, New Delhi 110002
Telephones : 331 01 31, 331 13 75

Telegrams : Manaksanstha
(Common to all Offices)

Regional Offices:

Central : Manak Bhavan, 9 Bahadur Shah Zafar Marg NEW DELHI 110002	{ 331 01 31 331 13 75
Eastern : 1/14 C.I.T. Scheme VII M, V.I.P. Road, Maniktola CALCUTTA 700054	37 86 62
Northern : SCO 445-446, Sector 35-C, CHANDIGARH 160036	2 18 43
Southern : C.I.T. Campus, IV Cross Road, MADRAS 600113	41 29 16
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